

Date: Friday, 17/08/2007 11:21:45 AM  
 User: Linda Lacelle

## Process Sheet

|                       |   |                  |               |
|-----------------------|---|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                     | Drawing Name     | : DOUBLER     |
| Job Number            | : 34098   |                  |               |
| Estimate Number       | : 12405   |                  |               |
| P.O. Number           | : N/A   | Part Number      | : D346720     |
| This Issue            | : 17/08/2007 S.O. No. : N/A   | Drawing Number   | : D3467 REV.B |
| Prsht Rev.            | : NC  | Project Number   | : N/A         |
| First Issue           | : N/A Type : PURCHASED PARTS  | Drawing Revision | : B           |
| Previous Run          | : 32048   | Material         | : N/A         |
| Written By            | :   | Due Date         | : 11/09/2007  |
| Checked & Approved By | : <i>[Signature]</i>  | Qty:             | 10 Um: Each   |
| Comment               | : est rev. A 06.04.20 new issue EC<br>Est Rev:B As per Rev B 06-05-24 JLM |                  |               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                     |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 0.0776 sf(s)/Unit Total : 0.7760 sf(s)  
 304/316 0.018 SHEET batch: *M165445 1B 07-08-29*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 Cut as per Dwg D3467  
 Dwg Rev: *B* *1B 07-08-29*  
 Prog Rev: *B*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*En 07/08/30*

*X10 counter*

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr

2-Form as per dwg D3467 using DT8852

*X10*  
*ml 07/08/30*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

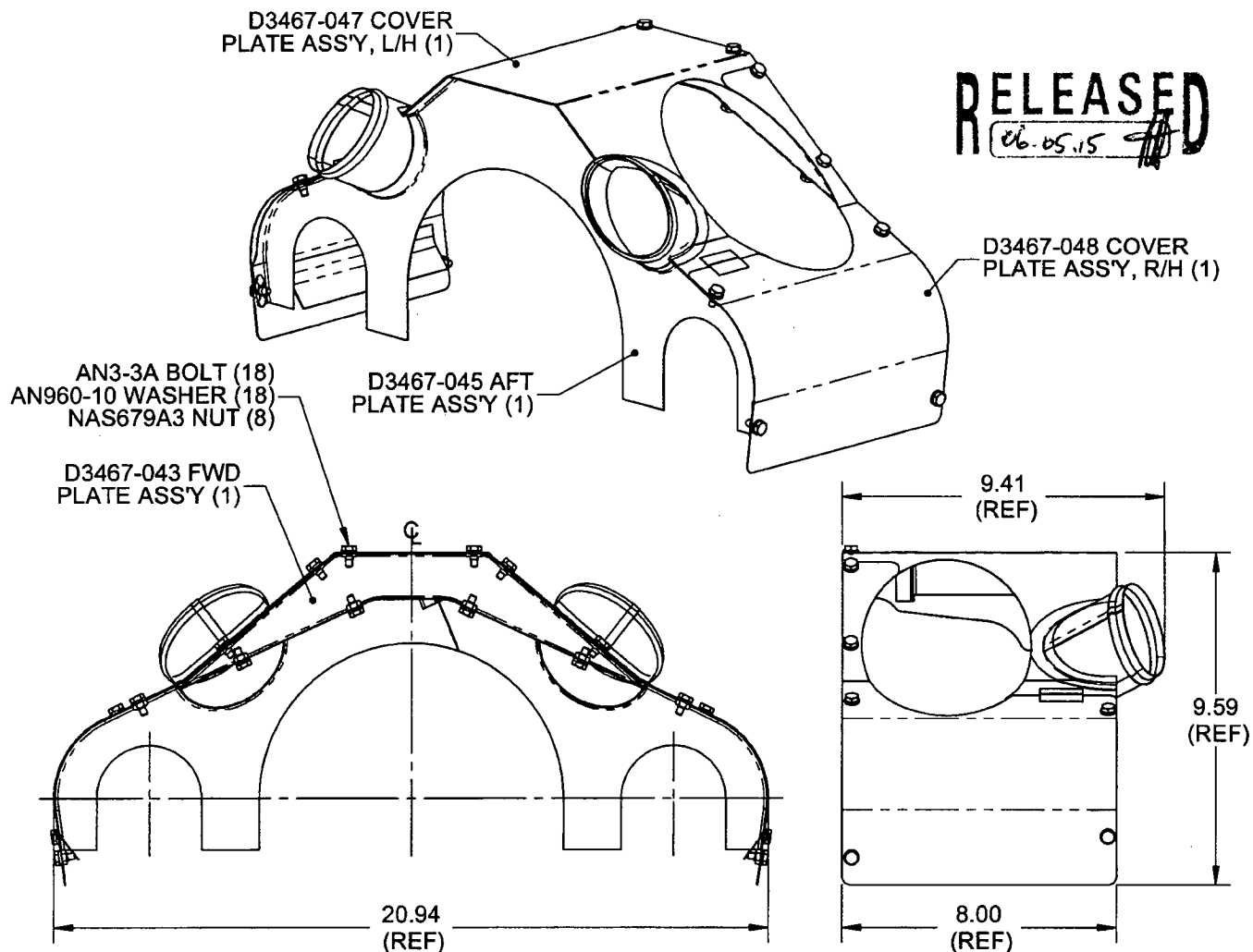
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                  |                |  |                         |
|------------------|----------------|--|-------------------------|
| DESIGN<br>13     | DRAWN BY<br>13 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA      |                         |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D3467                                   | REV. B<br>SHEET 1 OF 15 |
| DATE<br>06.05.15 |                | TITLE<br>SHROUD ASSEMBLY                               | SCALE<br>1:5            |
| A                | 05.12.07       | NEW ISSUE  |                         |
| B                | 06.05.15       | Ø0.250 & Ø0.203 WERE Ø0.194 ;<br>UPDATED D3467-9F/-15F |                         |



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N       | DESCRIPTION               |
|-------------|-----------|---------------------------|
| X           | D3467-041 | SHROUD ASSEMBLY           |
|             |           | SHOP COPY                 |
| 1           | D3467-043 | FWD PLATE ASSEMBLY        |
| 1           | D3467-045 | AFT PLATE ASSEMBLY        |
| 1           | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| 1           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 18          | AN3-3A    | BOLT                      |
| 18          | AN960-10  | WASHER                    |
| 8           | NAS679A3  | NUT                       |

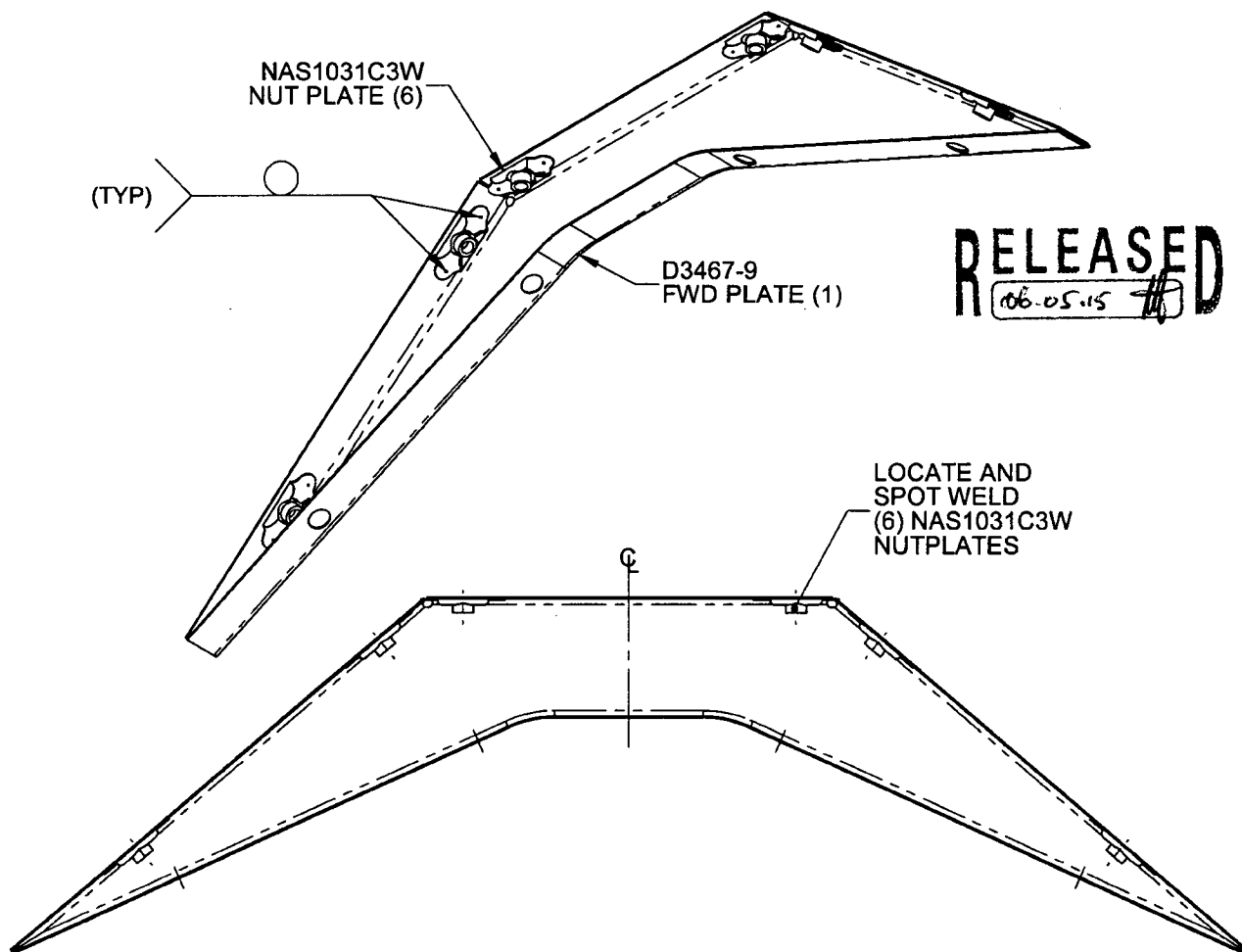
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





|                  |                |   |                         |
|------------------|----------------|---|-------------------------|
| DESIGN<br>13     | DRAWN BY<br>13 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br>13    | APPROVED<br>13 | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 2 OF 15 |
| DATE<br>06.05.15 |                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2            |



| QTY<br>-043 | P/N        | DESCRIPTION        |
|-------------|------------|--------------------|
| X           | D3467-043  | FWD PLATE ASSEMBLY |
| 1           | D3467-9    | FWD PLATE          |
| 6           | NAS1031C3W | NUT PLATE          |

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34098

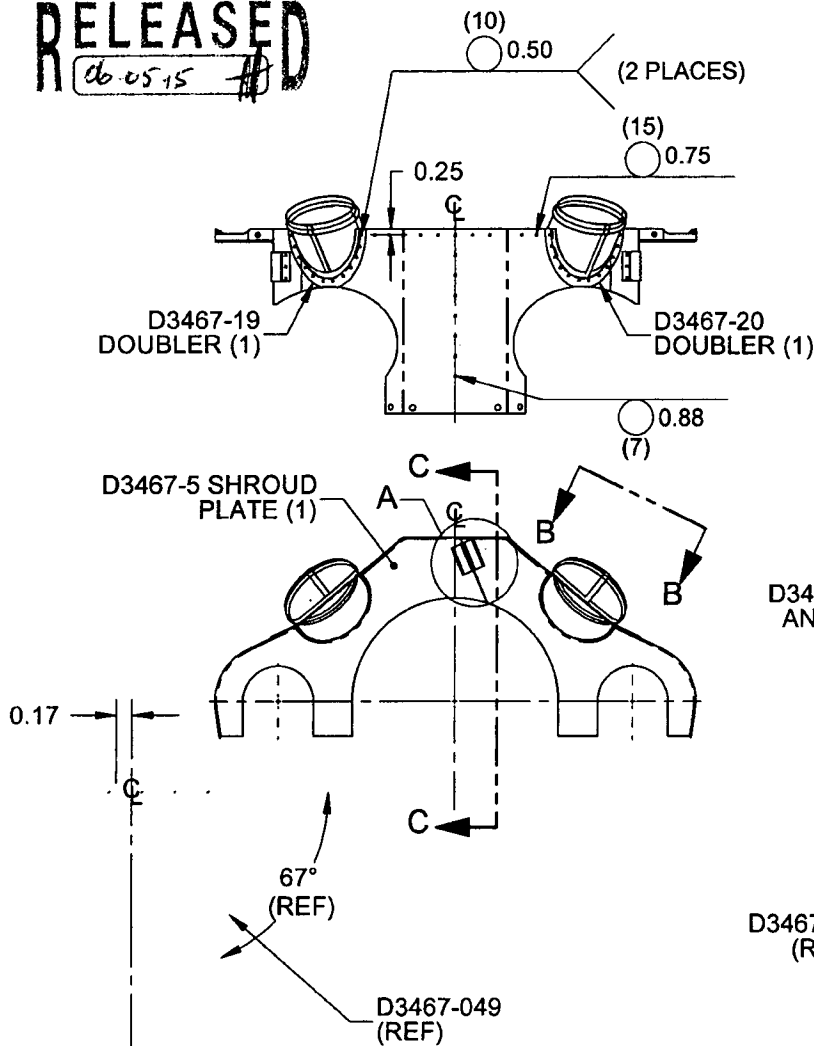
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

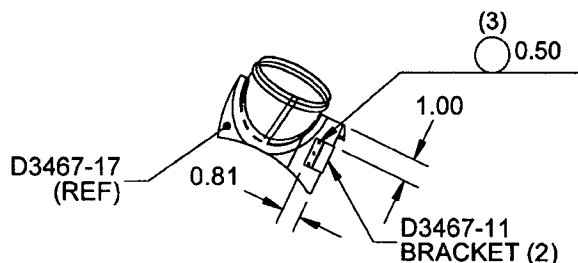
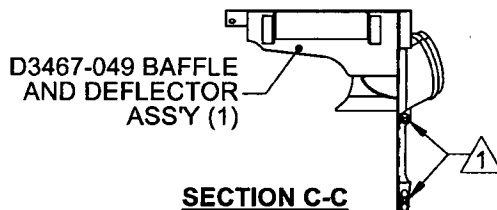
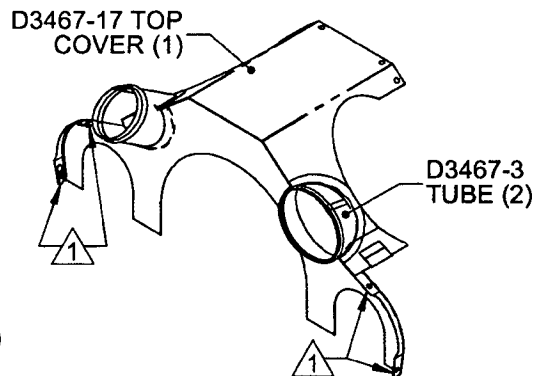


|                               |                                |   |                         |
|-------------------------------|--------------------------------|---|-------------------------|
| DESIGN<br><i>B</i>            | DRAWN BY<br><i>B</i>           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 3 OF 15 |
| DATE<br>06.05.15              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:8            |

RELEASED  
06-05-15



DETAIL A  
SCALE 1:2



VIEW B-B: WELDING D3467-11  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)

### D3467-045 AFT PLATE ASSEMBLY

#### NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

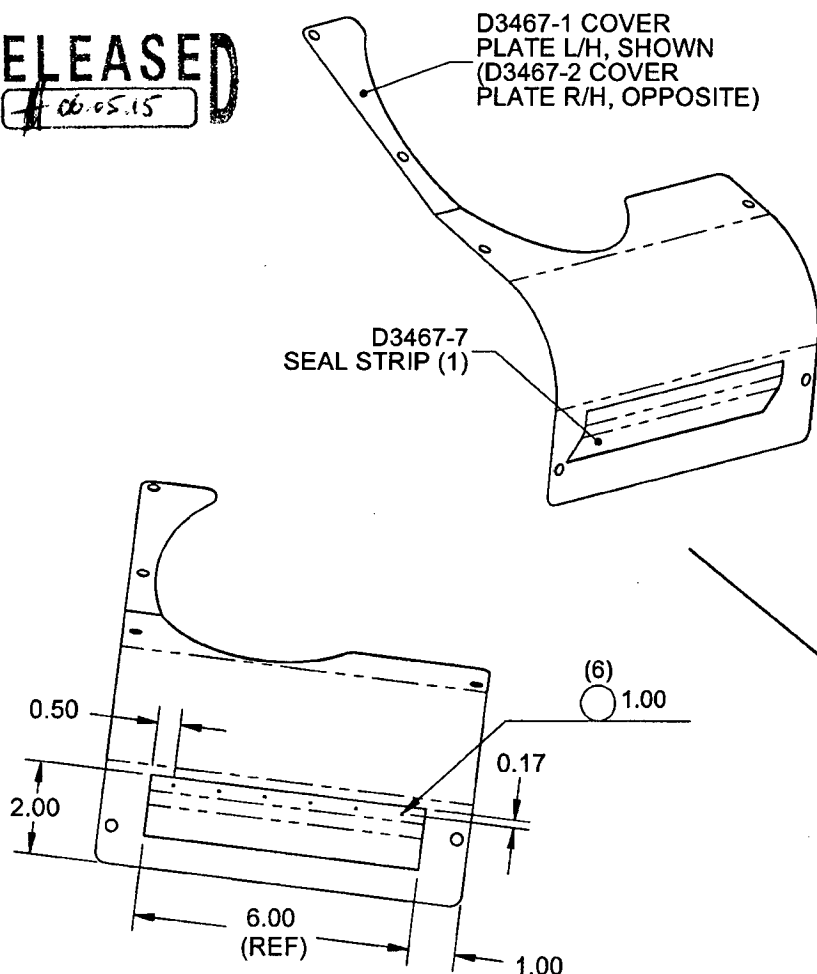
| QTY<br>-045 | P/N        | DESCRIPTION                   |
|-------------|------------|-------------------------------|
| X           | D3467-045  | AFT PLATE ASSEMBLY            |
| 1           | D3467-049  | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2           | D3467-3    | TUBE                          |
| 1           | D3467-5    | SHROUD PLATE                  |
| 2           | D3467-11   | BRACKET                       |
| 1           | D3467-17   | TOP COVER                     |
| 1           | D3467-19   | DOUBLER                       |
| 1           | D3467-20   | DOUBLER                       |
| 4           | NAS1031C3W | NUT PLATE                     |

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                         |                |  |                         |
|-------------------------|----------------|--|-------------------------|
| DESIGN<br>13            | DRAWN BY<br>13 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br>13           | APPROVED<br>13 | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 4 OF 15 |
| DATE<br><b>06.05.15</b> |                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4            |

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

SHOP COPY  
30°  
TURN TO  
(REF) ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORD  
NO. 34098

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-047 | QTY<br>-048 | P/N       | DESCRIPTION               |
|-------------|-------------|-----------|---------------------------|
| X           |             | D3467-047 | COVER PLATE ASSEMBLY, L/H |
|             | X           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1           |             | D3467-1   | COVER PLATE, L/H          |
|             | 1           | D3467-2   | COVER PLATE, R/H          |
| 1           | 1           | D3467-7   | SEAL STRIP                |

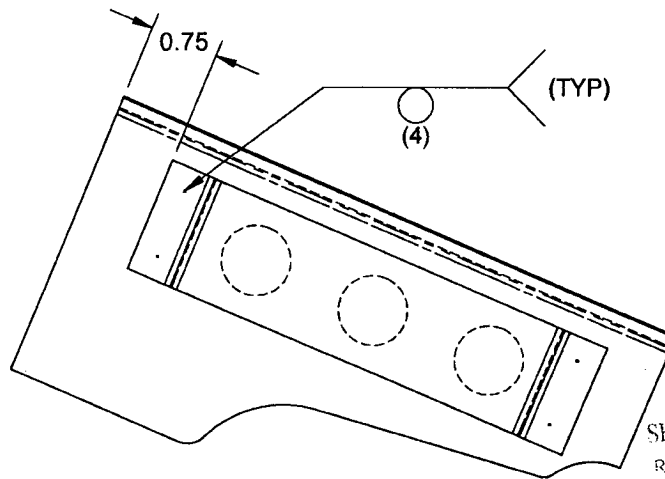
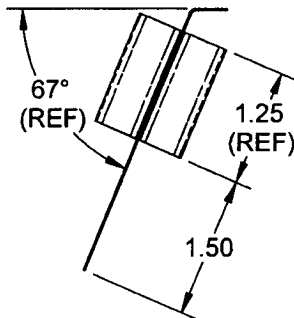
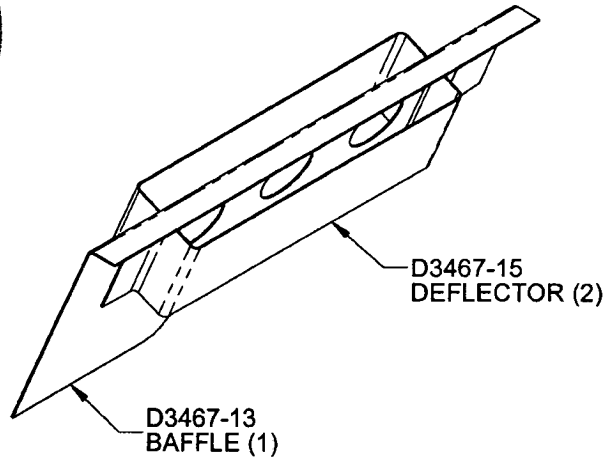
**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



|                               |                                |   |                         |
|-------------------------------|--------------------------------|---|-------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 5 OF 15 |
| DATE<br>06.05.15              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2            |

RELEASED  
*[Stamp]* 06.05.15



**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34098*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-049 | P/N       | DESCRIPTION                 |
|-------------|-----------|-----------------------------|
|             | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1           | D3467-13  | BAFFLE                      |
| 2           | D3467-15  | DEFLECTOR                   |

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

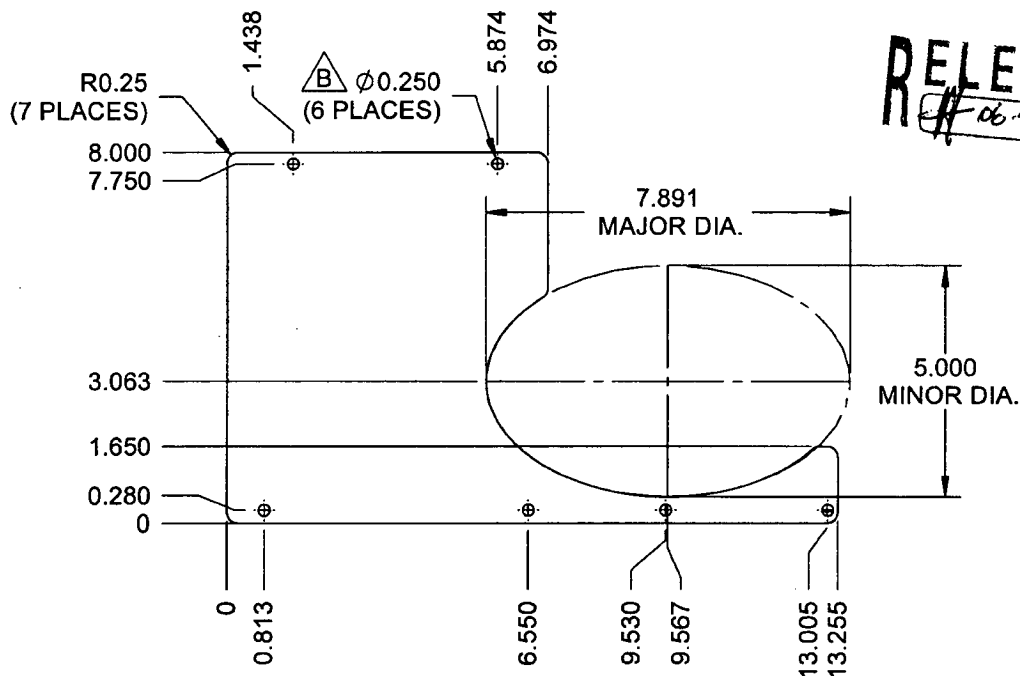
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



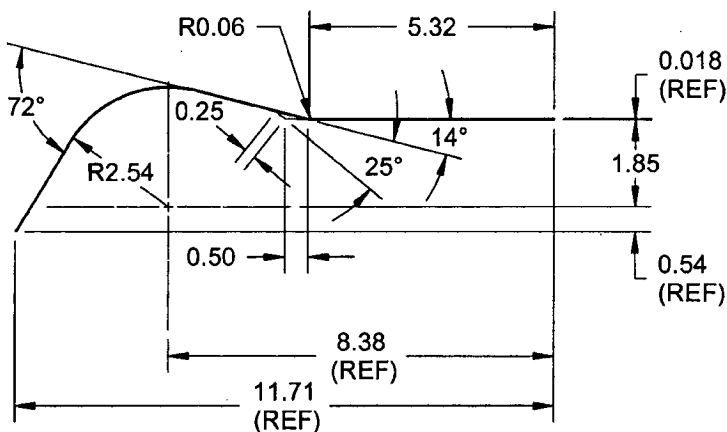




|                  |                 |   |                         |
|------------------|-----------------|---|-------------------------|
| DESIGN<br>#13    | DRAWN BY<br>#13 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br>#1    | APPROVED<br>#1  | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 6 OF 15 |
| DATE<br>06.05.15 |                 | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |



### D3467-1F COVER PLATE FLAT PATTERN



### D3467-1 L/H COVER PLATE D3467-2 R/H COVER PLATE (OPPOSITE)

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

### D3467-1 L/H COVER PLATE ISOMETRIC VIEW.

### D3467-2 R/H COVER PLATE (OPPOSITE)

SCALE 1:8 R/V TO

ENGINEERING

CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 34098

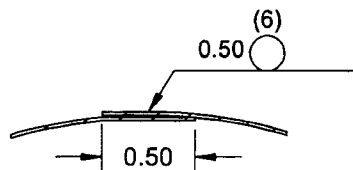
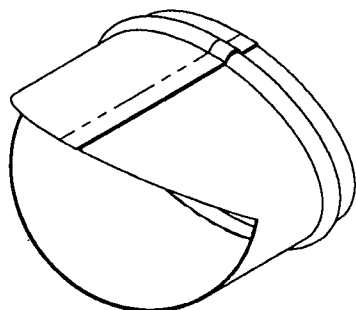
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

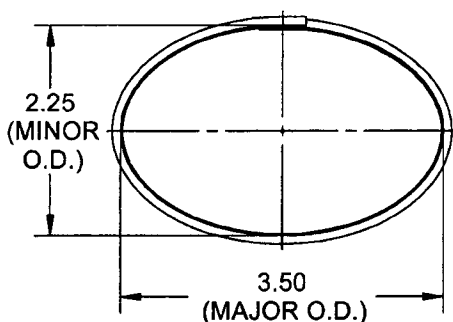


|                         |                       |  |                         |
|-------------------------|-----------------------|--|-------------------------|
| DESIGN<br><i>13</i>     | DRAWN BY<br><i>13</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>#</i>     | APPROVED<br><i>#</i>  | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 7 OF 15 |
| DATE<br><b>06.05.15</b> |                       | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

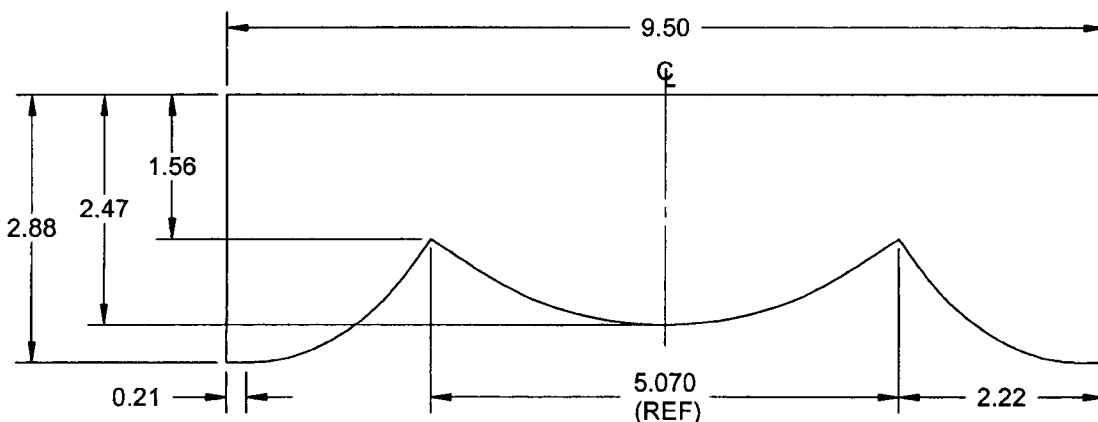
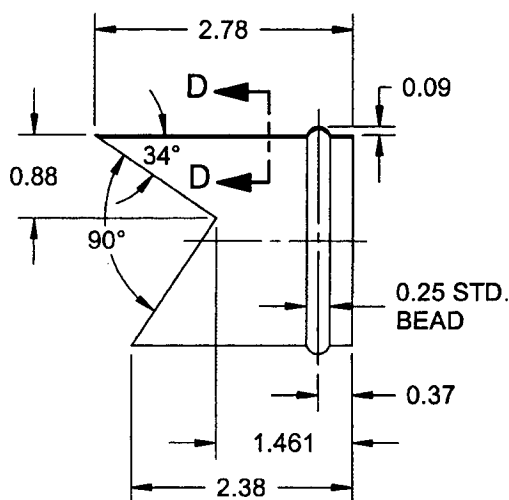
**RELEASED**  
*06.05.15*



**SECTION D-D**  
SCALE 1:1



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

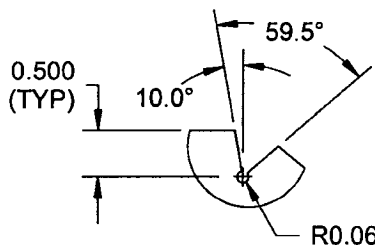
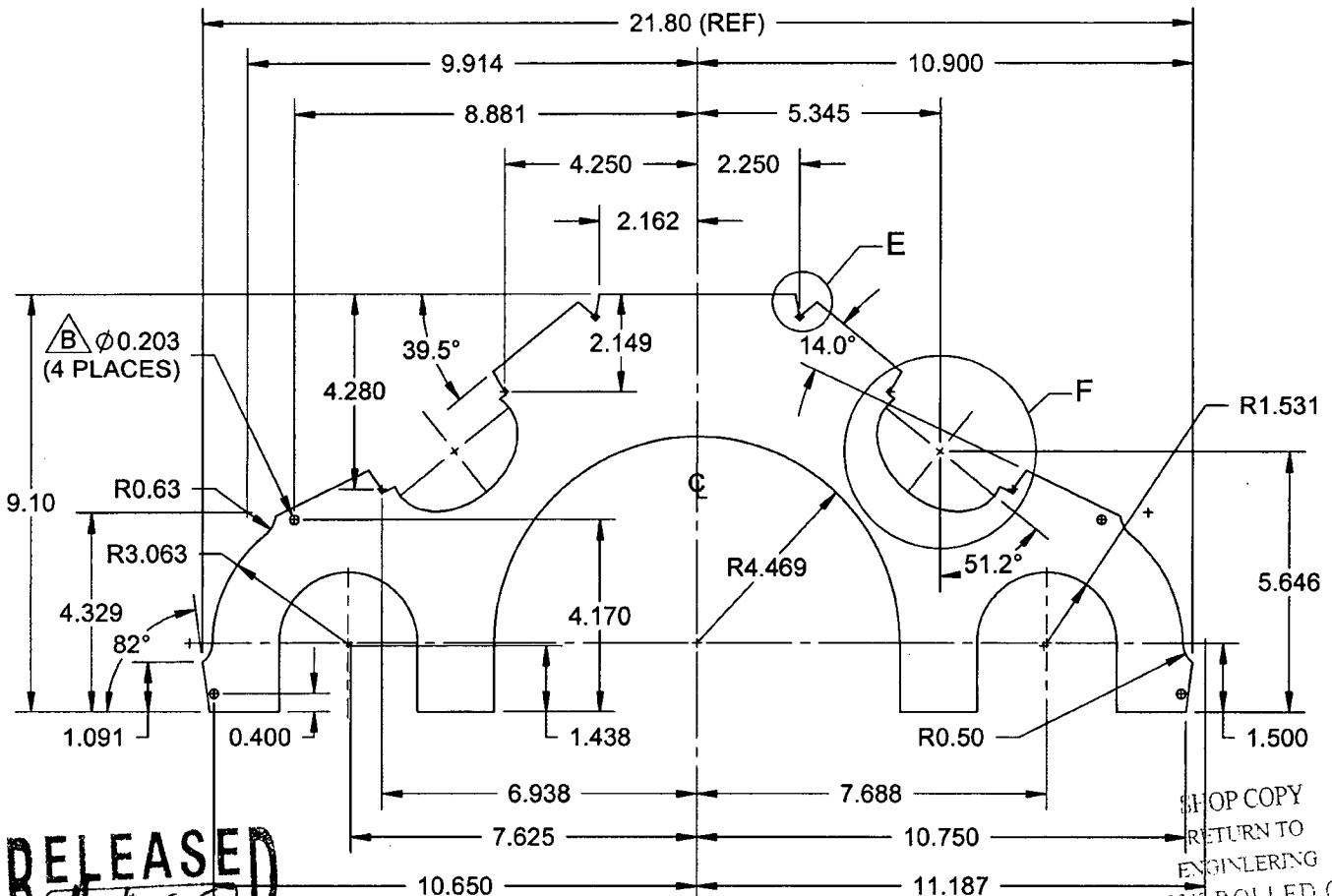
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34098*

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

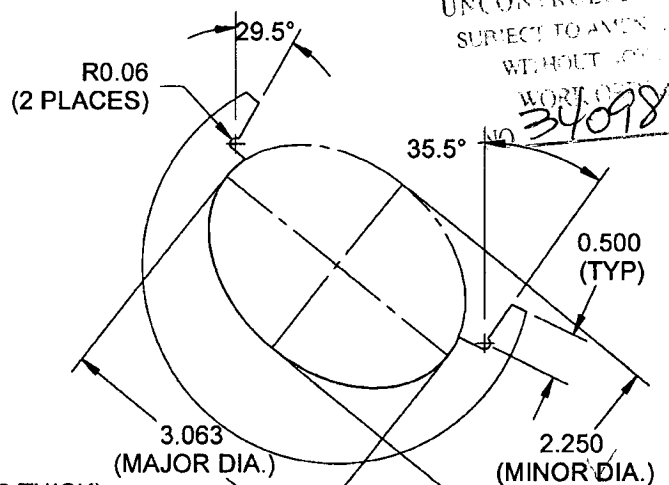
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                               |                                |  |                         |
|-------------------------------|--------------------------------|--|-------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 8 OF 15 |
| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |



**DETAIL E**  
SCALE 1:2



**DETAIL F**  
SCALE 1:2

### **D3467-5F AFT PLATE FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

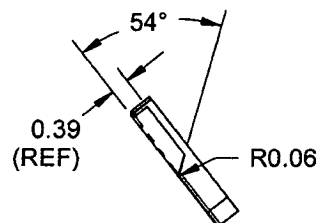
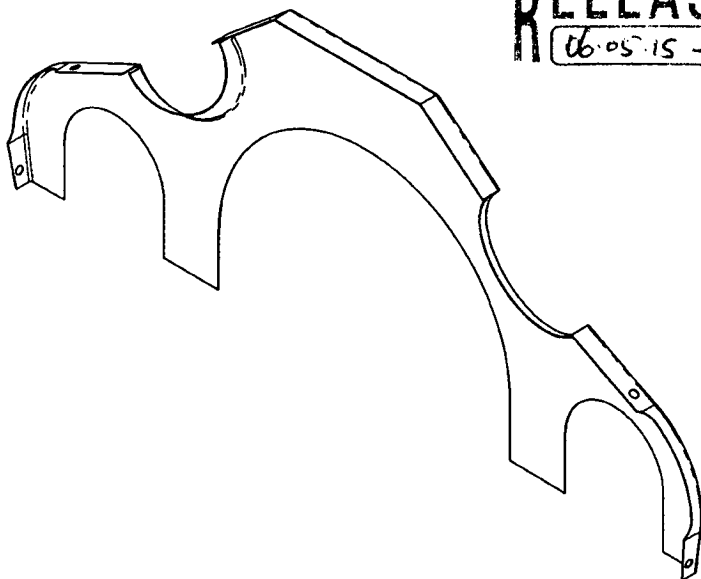
**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

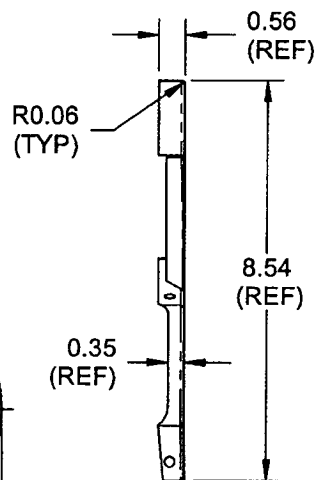
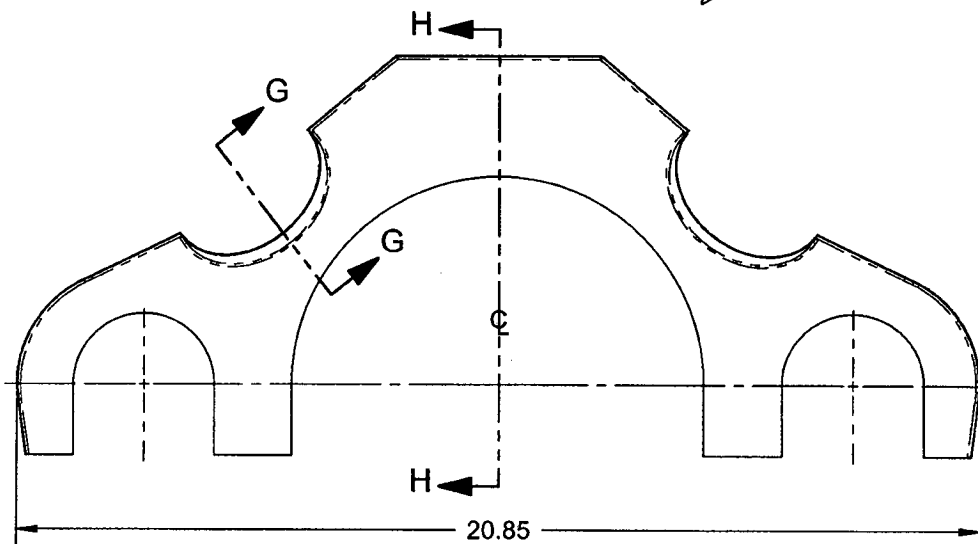


|                     |                      |   |                         |
|---------------------|----------------------|---|-------------------------|
| DESIGN<br><i>B</i>  | DRAWN BY<br><i>B</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>H</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 9 OF 15 |
| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |

RELEASED  
06.05.15 *H*



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34098*

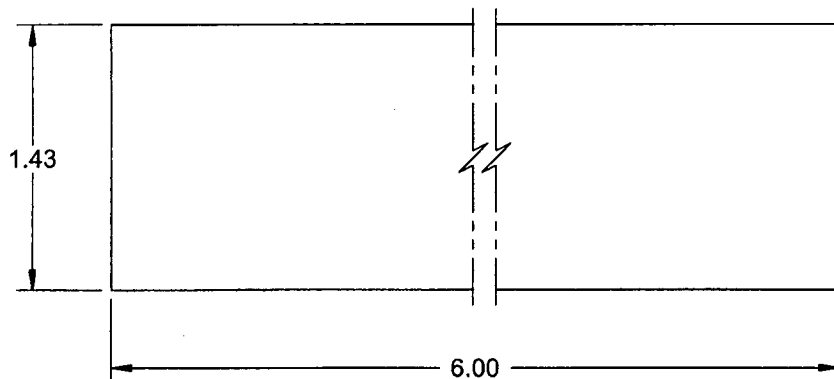
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

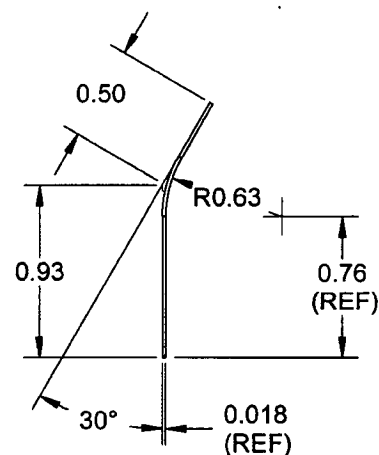


|                         |                      |  |                          |
|-------------------------|----------------------|--|--------------------------|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>#</i>     | APPROVED<br><i>#</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 10 OF 15 |
| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:1             |

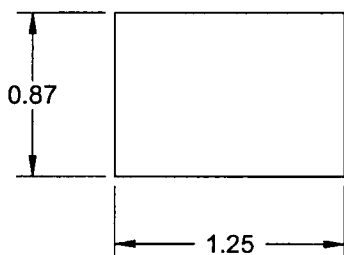
**RELEASED**  
06.05.15 *#*



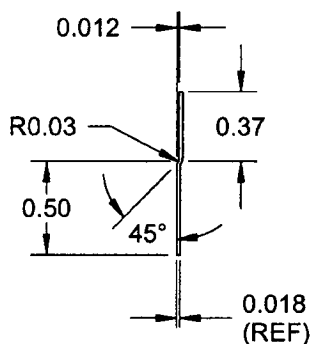
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

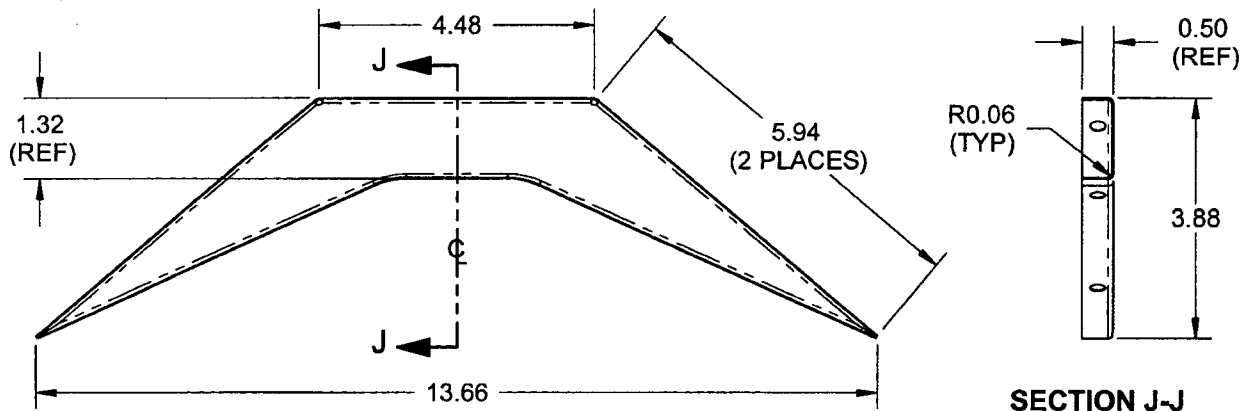
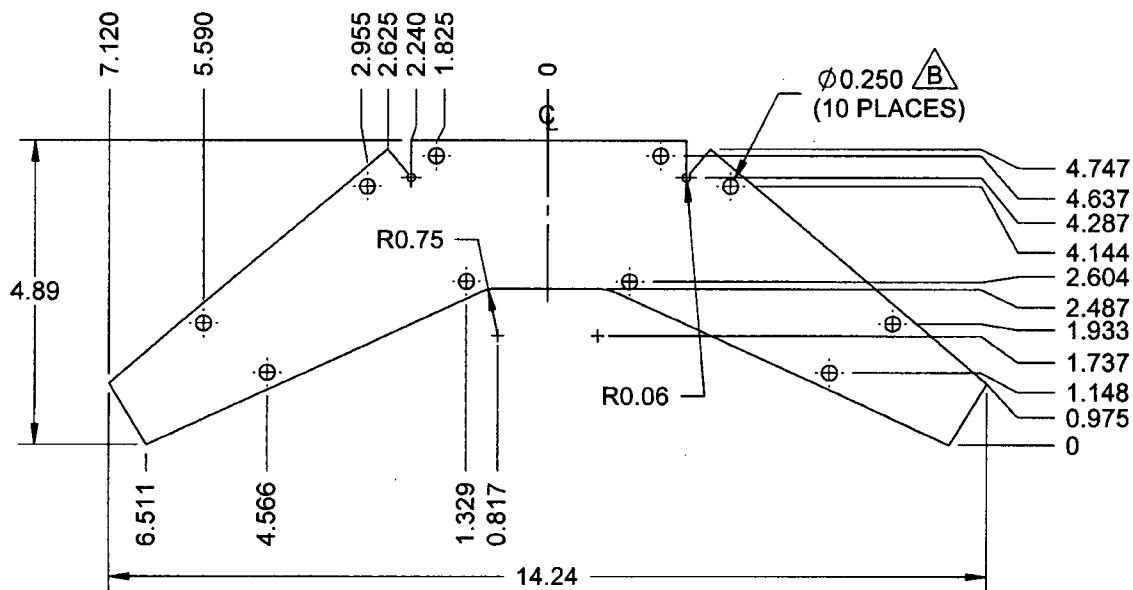
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. *34098*

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                               |                                 |  |
|-------------------------------|---------------------------------|--|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i>  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>  | DRAWING NO.<br><b>D3467</b>                              |
| DATE<br><b>06.05.15</b>       | TITLE<br><b>SHROUD ASSEMBLY</b> | REV. B<br>SHEET 11 OF 15<br>SCALE<br>1:3                 |

**RELEASED**  
*[Signature]* 06.05.15**D3467-9 FWD PLATE BENDING DETAIL****D3467-9F FWD PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34098**

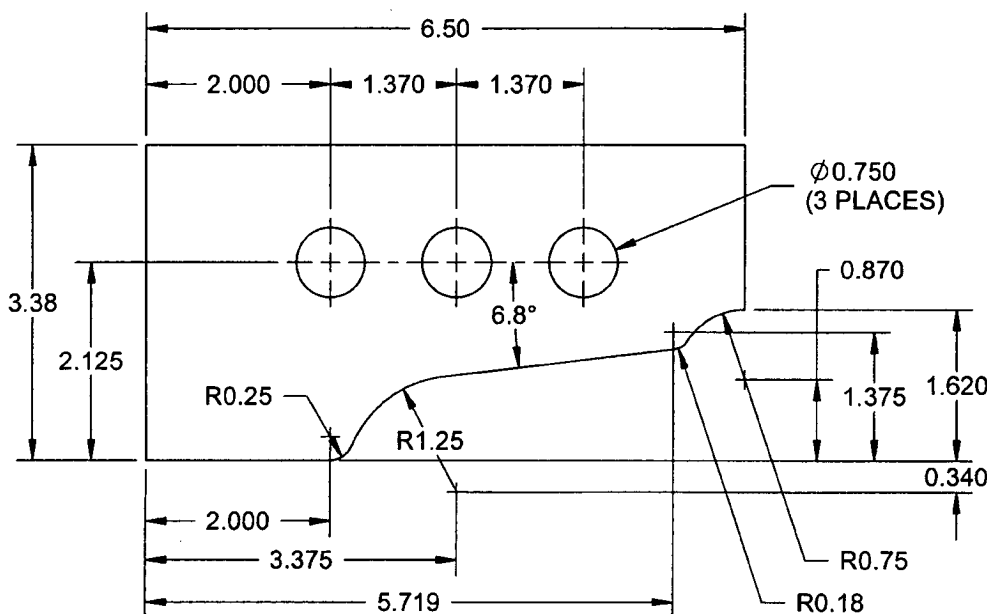
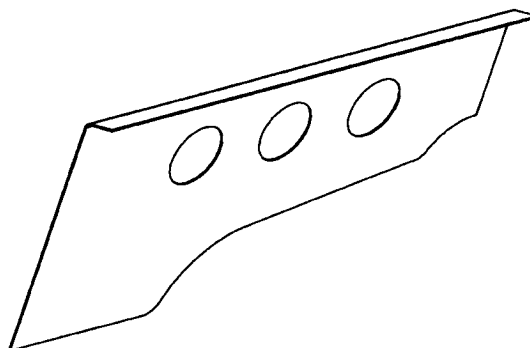
**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

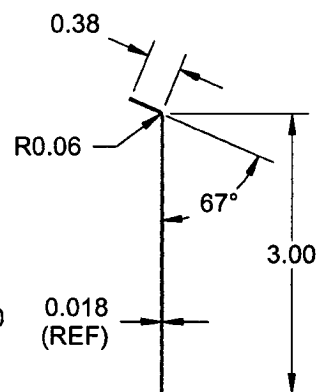


|                               |                                |   |                          |
|-------------------------------|--------------------------------|---|--------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 12 OF 15 |
| DATE<br>06.05.15              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2             |

RELEASED  
*[Signature]* 06.05.15



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. **34098**

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

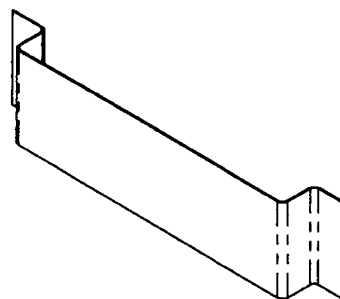
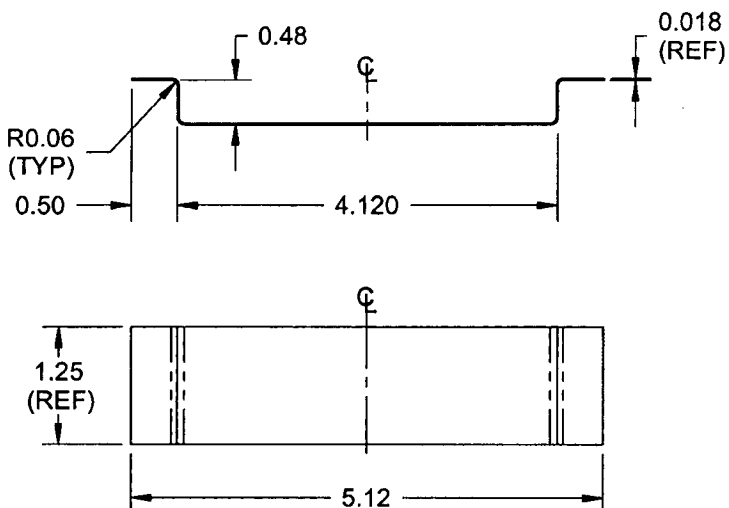
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



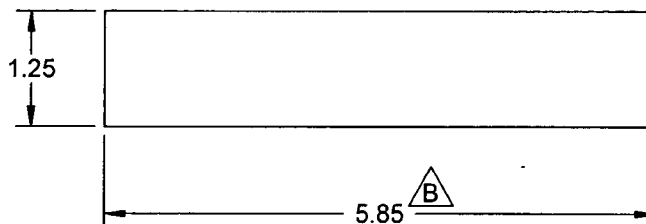


|                     |                      |   |                          |
|---------------------|----------------------|---|--------------------------|
| DESIGN<br><i>B</i>  | DRAWN BY<br><i>B</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>H</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3467                              | REV. B<br>SHEET 13 OF 15 |
| DATE<br>06.05.15    |                      | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2             |

RELEASED  
*06.05.15*



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B **FINISH**  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

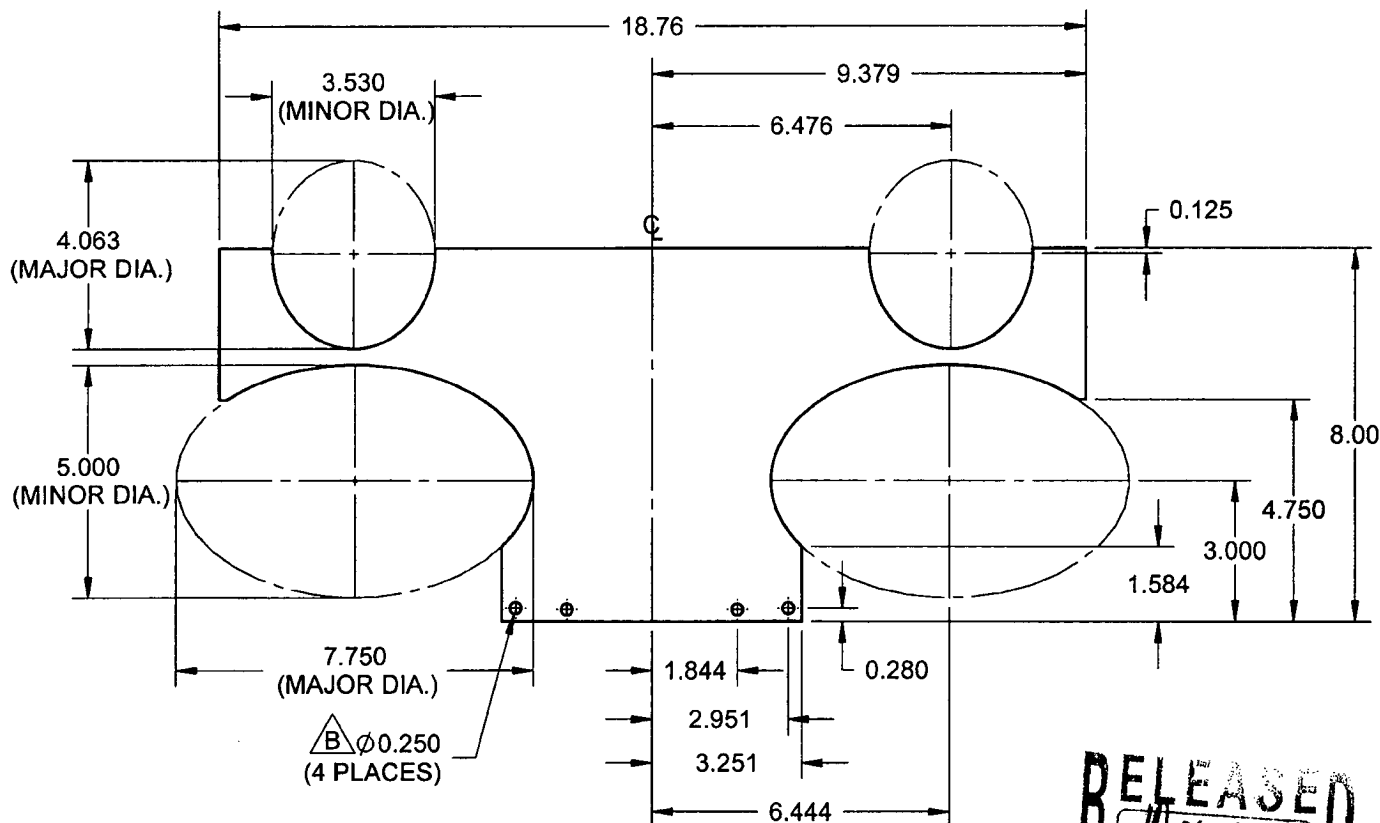
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34098*

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

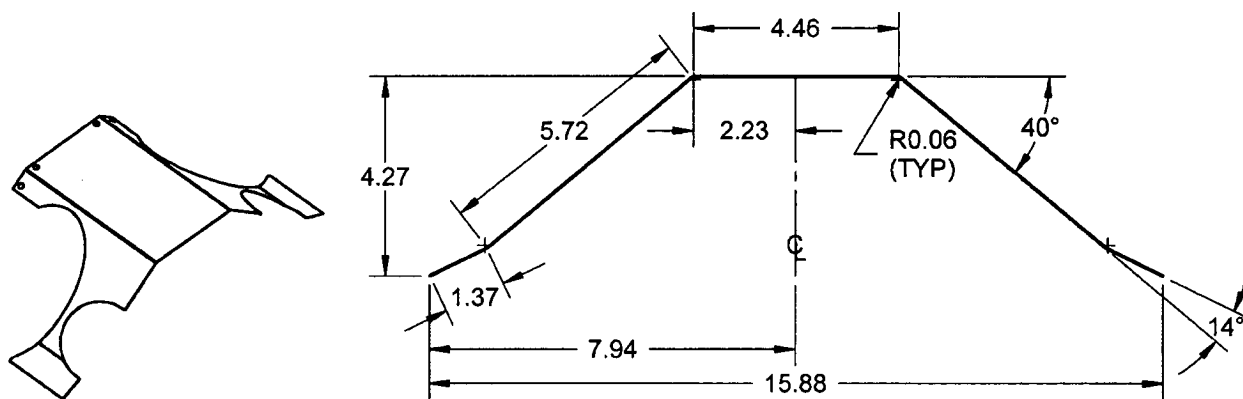


|                         |                       |  |                          |
|-------------------------|-----------------------|--|--------------------------|
| DESIGN<br><i>JB</i>     | DRAWN BY<br><i>JB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>JB</i>    | APPROVED<br><i>JB</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 14 OF 15 |
| DATE<br><b>06.05.15</b> |                       | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4             |



**D3467-17F TOP COVER FLAT PATTERN**

**RELEASED**  
#06-05-15



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34098**

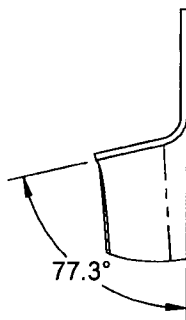
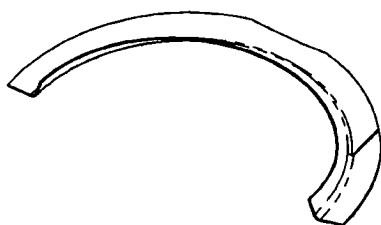
**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

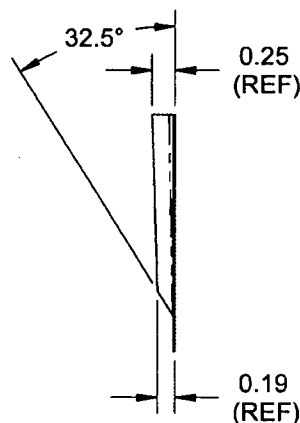
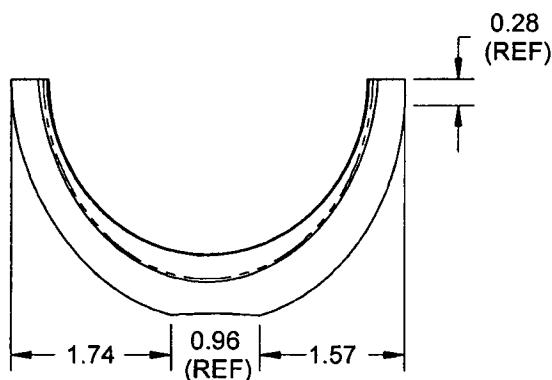
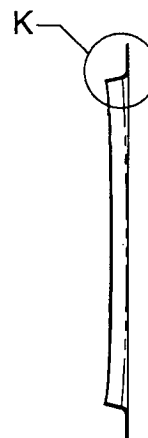


|                         |                                 |  |
|-------------------------|---------------------------------|--|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i>            | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>H</i>     | APPROVED<br><i>H</i>            | DRAWING NO.<br><b>D3467</b><br>REV. B<br>SHEET 15 OF 15  |
| DATE<br><b>06.05.15</b> | TITLE<br><b>SHROUD ASSEMBLY</b> | SCALE<br>1:2   |

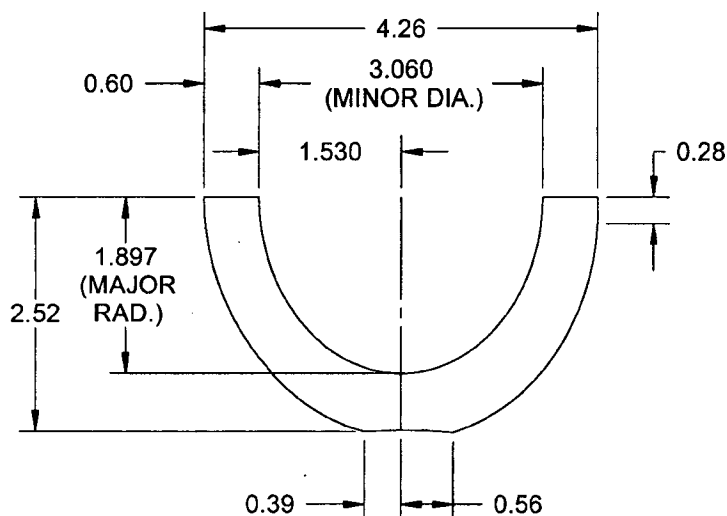
**RELEASED**  
*db vs 15*



**DETAIL K**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

**D3467-19F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Date: Friday, 17/08/2007 11:21:45 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 34098

Part Number: D346720

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/04 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location GA

SB 07/09/06 10

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)  
07/09/06

Job Completion



U 07-09-06

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries